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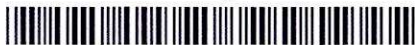
D3913-041
Job Sheet 212850



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/8/20

Job Tracking No:

Due Date: 10/16/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/15/20		0.00	19.61	Large Fab - 1		MAC OCT 01 2020
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	10/15/20		0.00	0.00	QC 9 - 10		DAS 24 9-89 OCT 08 2020
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	10/15/20		0.00	0.00	QC 5 - 10		DAS 24 9-89 OCT 08 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

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					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
					QC 5 - 82		
125	Handfinish - 2-1 Pressure-B4B	1 pcs	10/15/20	0.00 0.29	Handfinish - 2 - 1 - B4B	20-10-14	DAS 34 9-89
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	10/15/20	0.00 0.93	Powdercoat - 1 - B4B		
	M254469.				Powdercoat - 2 - B4B		
	START: 7:40.				Powdercoat - 3 - B4B	20-10-15	DAS 33 9-89
	OV: 3:35				Powdercoat - 4 - B4B		
	FINISH: 8:10.				Powdercoat - 5 - B4B		
					Powdercoat - 6 - B4B		
					Powdercoat - 7 - B4B		
					Powdercoat - 8 - B4B		
					Powdercoat - 9 - B4B		
					Powdercoat - 10 - B4B		
140	QC 3	1 pcs	10/15/20	0.00 0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15	20-10-15	DAS 15 9-89
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
					QC 3 - 87		
					QC 3 - 47		
150	Handfinish - 4-1-Assembly-B4B	1 pcs	10/16/20	0.00 0.50	Handfinish - 4 - 1 - B4B	20-10-15	
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 -		

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						B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
						160 QC 5	1 pcs
QC 5 - 12							
QC 5 - 17							
QC 5 - 18							
QC 5 - 19							
QC 5 - 22							
QC 5 - 24							
QC 5 - 3							
QC 5 - 43							
QC 5 - 49							
QC 5 - 51							
QC 5 - 58							
QC 5 - 68							
QC 5 - 9							
QC 5 - 50							
QC 5 - 30							
QC 5 - 40							
QC 5 - 61							
QC 5 - 81							
QC 5 - 82							
170 Packaging 3-1 - Stock - B4B	1 pcs	10/16/20	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
							Plex 9/8/20 9:22 AM Dart.Renwick.Jennife

DAS
81
9-89

OCT 15 2020

					Packaging 3 - 15 - B4B	HL 10.10.15
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
				0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 9	9-80
					QC 21 - SA - 77	
					QC 21 - SA - 28	
180 QC 21 - SA	1	10/16/20				
	pcs					

OCT 15 2020

Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

#017474

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5265485
D3913-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5226446
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5267768
D3913-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5266451
D3913-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5255994
D3913-9 ✓	Hinge Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5266454
D3916-041 ✓	Rib Assembly	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5297556
D3916-5 ✓	Light Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5297570
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5257681
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5250092
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5302525
D4020-11 ✓	End Mesh, Basket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5297645
D4021-1 ✓	Handle Plate	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5253605
D4034-041 ✓	Aft Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5297811
D4034-043 ✓	Fwd Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5297936
D4672-1 ✓	Blanking Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5259507
M304EX0.75-16F ✓	Expanded Metal Flat SS	32 sf (32 ea) ✓	100-Large Fab - Basket - 1	52534161
AN3-10A ✓	BOLT	6 Ea (6 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	5286435
D2931 ✓	Bumper	2 pcs (2 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	5235355
MS20600-AD4W3 ✓	Cherry Rivet	2 Ea (2 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	5304836
MS21042L3 ✓	Nut	6 Ea (6 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	5216387
NAS1149F0332P ✓	Washer (AN960-10L)	12 Ea (12 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	5241506
D4021-5 ✓	Blanking Plate	2 pcs (2 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	5136364
NAS1149FN832P ✓	Washer (AN960-8)	2 Ea (2 ea) ✓	150-Handfinish - 4-1-Assembly-B4B	x

Job Allocations

017763

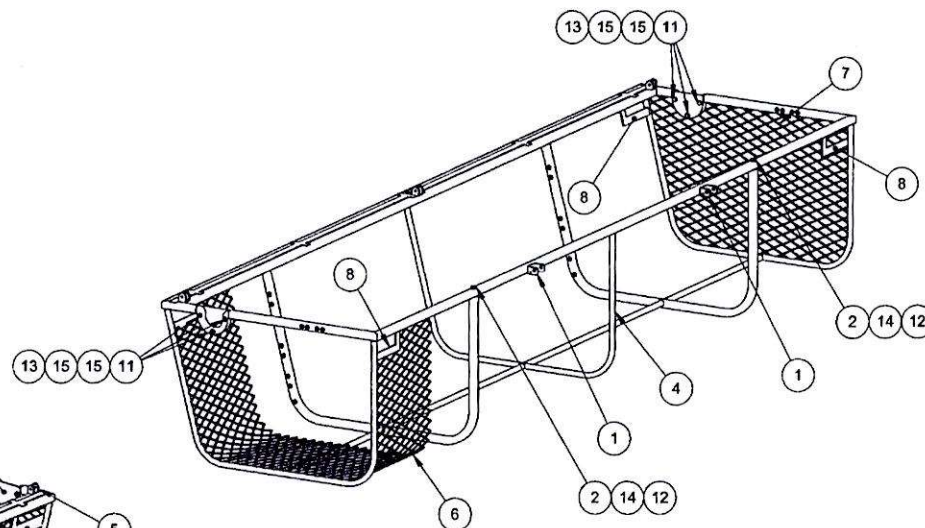
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	34	0
	D3913-1	1	5	0
	D3913-15	1	19	0
	D3913-3	1	5	0
	D3913-7	2	10	0
	D3913-9	1	6	0
	D3916-041	2	6	0
	D3916-5	3	12	0
	D4016-1	3	27	0
	D4017-7	3	42	0
	D4017-9	2	4	0
	D4020-11	2	6	0
	D4021-1	3	15	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	32	0
	M304EX0.75-16F	32	790	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	154	0
	D2931	2	455	0
	D4021-5	2	6	0
	MS20600-AD4W3	2	294	0
	MS21042L3	6	819	0
	NAS1149F0332P	12	2,114	0
	NAS1149FN832P	2	1,868	0

Part Specifications

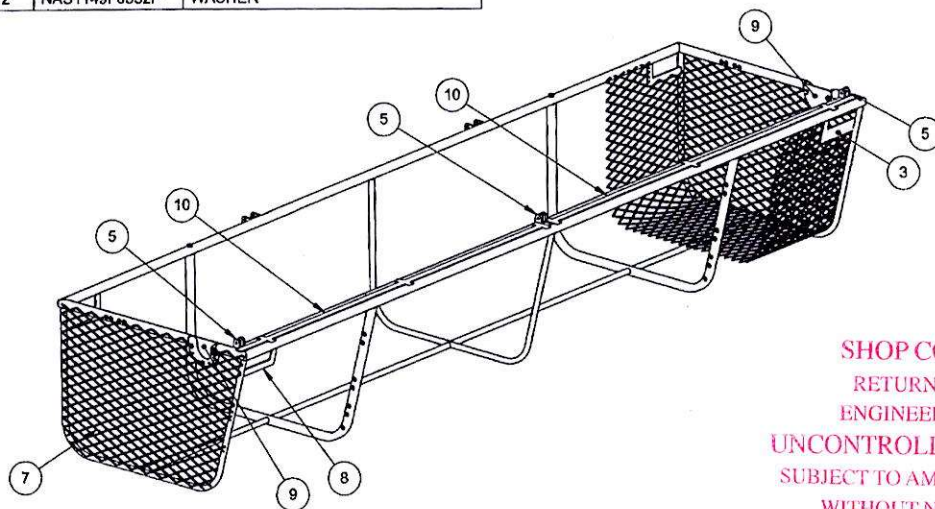
Specifications could not be found.

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212850

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

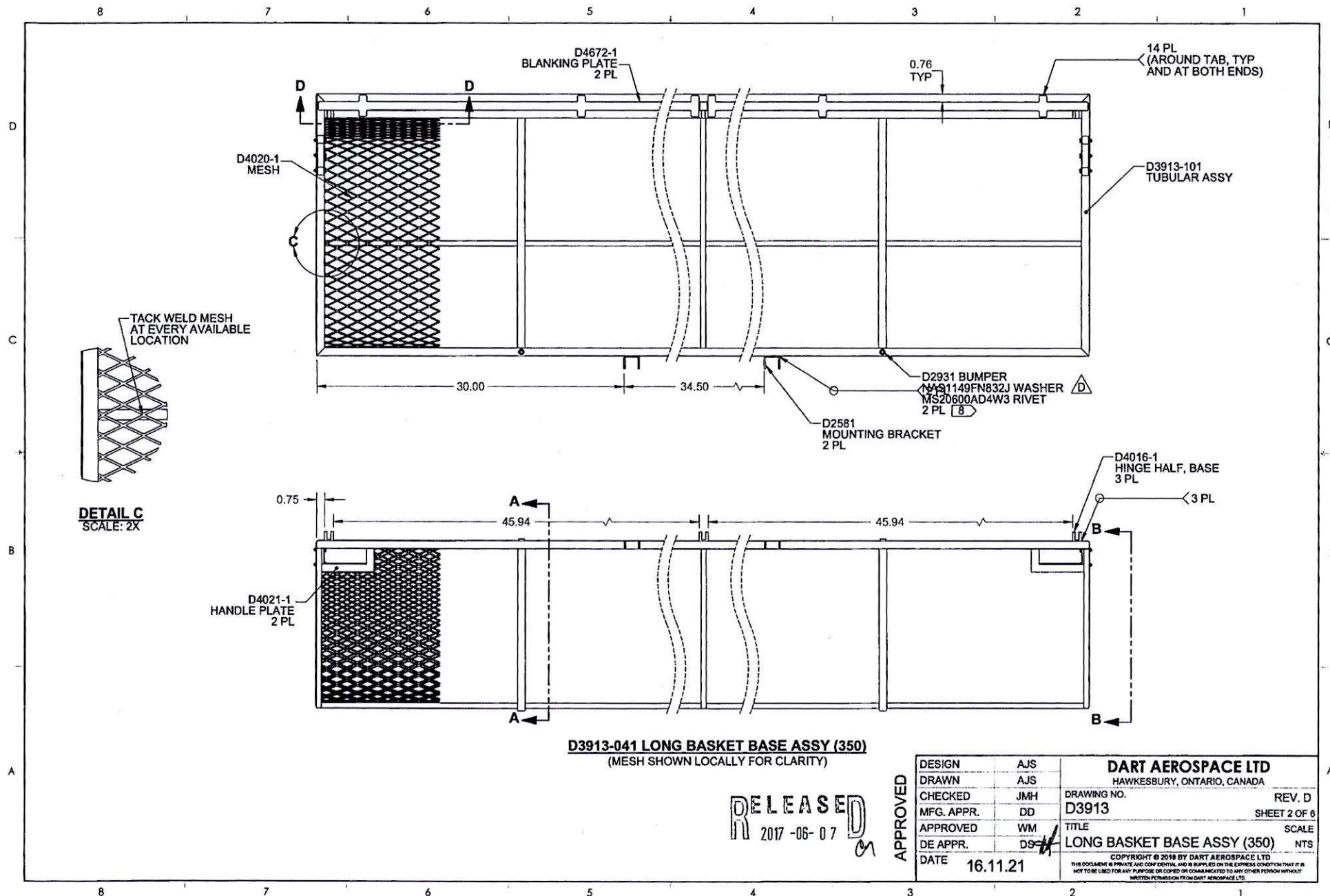


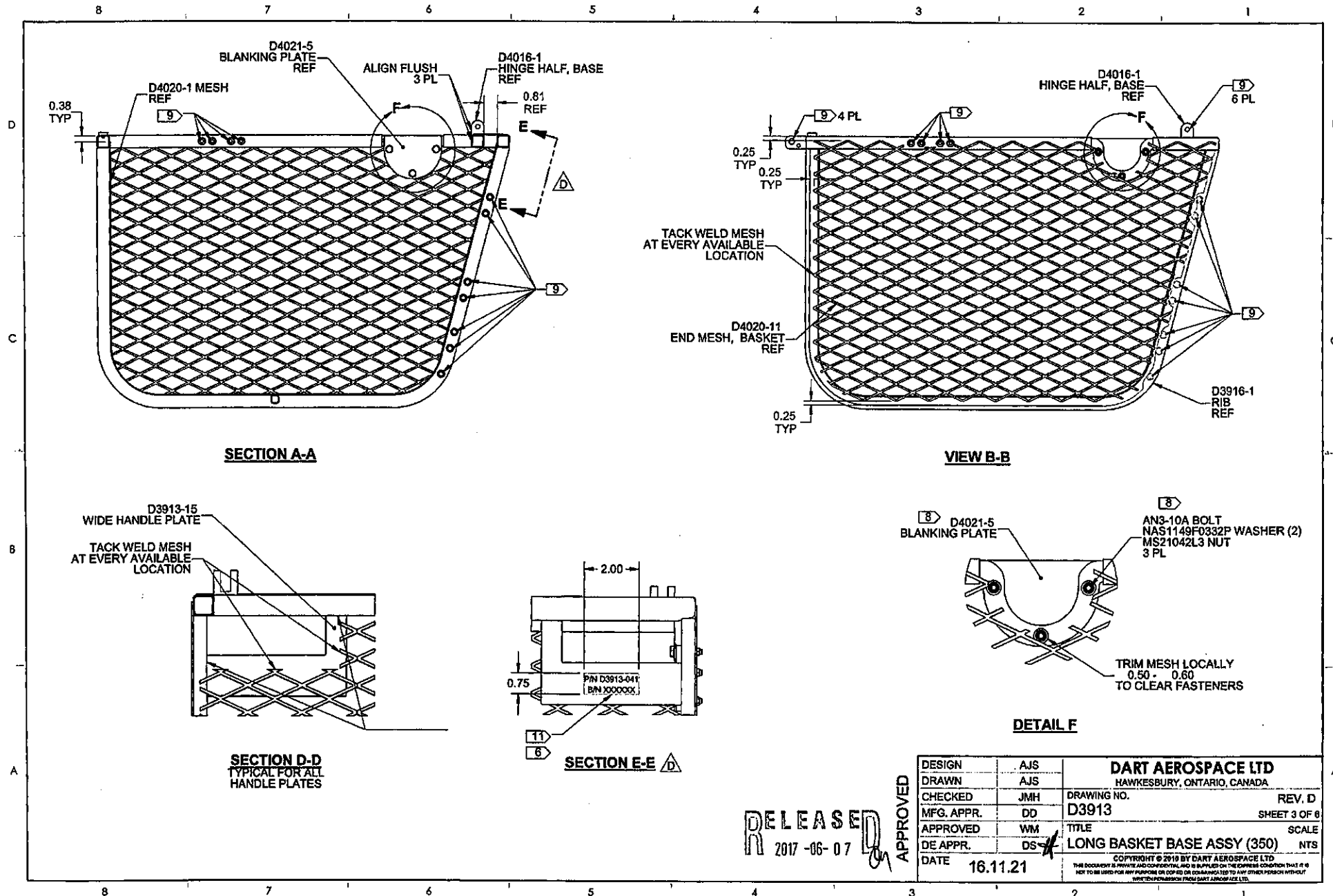
D	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN960JD8, UPDATED NOTE 6, ADDED NOTE 11. SHEET 3 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	D3	LONG BASKET BASE ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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RELEASED
2017-06-07
CLW 17-580

APPROVED





RELEASED
2017-06-07

APPROVED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			



Container No: S304236



Part: D3913 - 041

Job No: 212850

Serial No/Batch: S304236

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/01/20